

Work Order ID 56212

February 16, 2010 12:37:09 PM

Page 1

Item ID: D3608-3

Revision ID:

Item Name: Upper Doubler

Start Date: 2/16/10 Start Qty: 4.00

Required Date: 2/19/10 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3608

Rev B

100



Waterjet

FLOW CNC Waterjet

304 .040

FLOW WATER JET.

Memo

1-Cut as per Dwg D3608

Dwg Rev: B

Prog Rev: B
2-Deburr if necessary

0.00

0.00

18 10-2-17

4

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

18 10-2-17

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

8.10/12/18

74

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3608-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Upper Doubler

Start Date: 2/16/10 Start Qty: 4.00



Cust Item ID:

Required Date: 2/19/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

(0-2-18) (45) SQ

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/18 JF
mf
10-2-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56212



Parent Item: D3608-3



Parent Item Name: Upper Doubler

Start Date: 2/16/10

Required Date: 2/19/10

Comments:

IPP Rev:A New Issue 07-03-26 JLM
IPP Rev:B 08-10-15 preliminary issue DD verified by:EC
IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC
Rev:D 10.02.16 rev.B as per dwg DD verified by:EC

IPP

Start Qty: 4.00

Required Qty: 4.00

M304S20GA

Purchased

No

100

sf

179.2294 3.1124



10-2-17

304/316 .040 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

179.2294053

110076

0.40253684

112567

38.0765789

112885

36.9578

113062

95.2723

113077

8.52018947

112885

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 56212
Description: UPPER DOOR		Part Number: D3608-3
Inspection Dwg: D36083 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

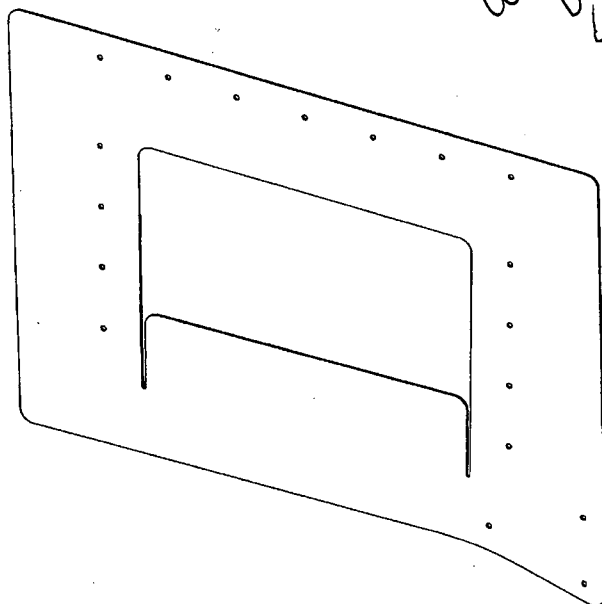
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.099	✓			
1.820	± .00	1.819	✓			
.500	± .010	.501	✓			
1.325	± .010	1.325	✓			
7.950	± .010	7.951	✓			
11.50	± .030	11.504	✓			
2.50	± .030	2.507	✓			
3.750	± .010	3.748	✓			
1.250	± .010	1.247	✓			
8.50	± .030	8.497	✓			
.75	± .030	.759	✓			
2.46	± .030	2.477	✓			
6.45	± .030	6.455	✓			
6.51	± .030	6.507	✓			
11.63	± .030	11.629	✓			
2.53	± .030	2.528	✓			
1.41	± .030	1.421	✓			
3.750	± .010	3.743	✓			
1.250	± .010	1.254	✓			
8.56	± .030	8.562	✓			
2.53	± .030	2.532	✓			
.040	± .010	.037	✓			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-2-17	Date: 10/2/18	Date:	N/A

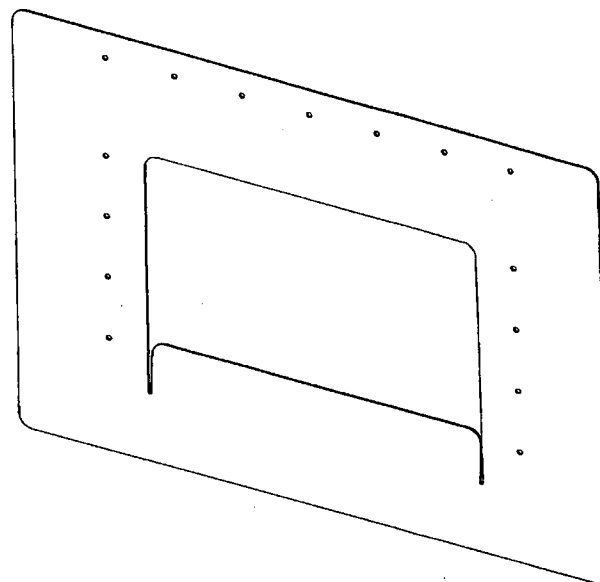
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

who 5622



D3608-1 LOWER DOUBLER



D3608-3 UPPER DOUBLER

RELEASED
2010-02-10

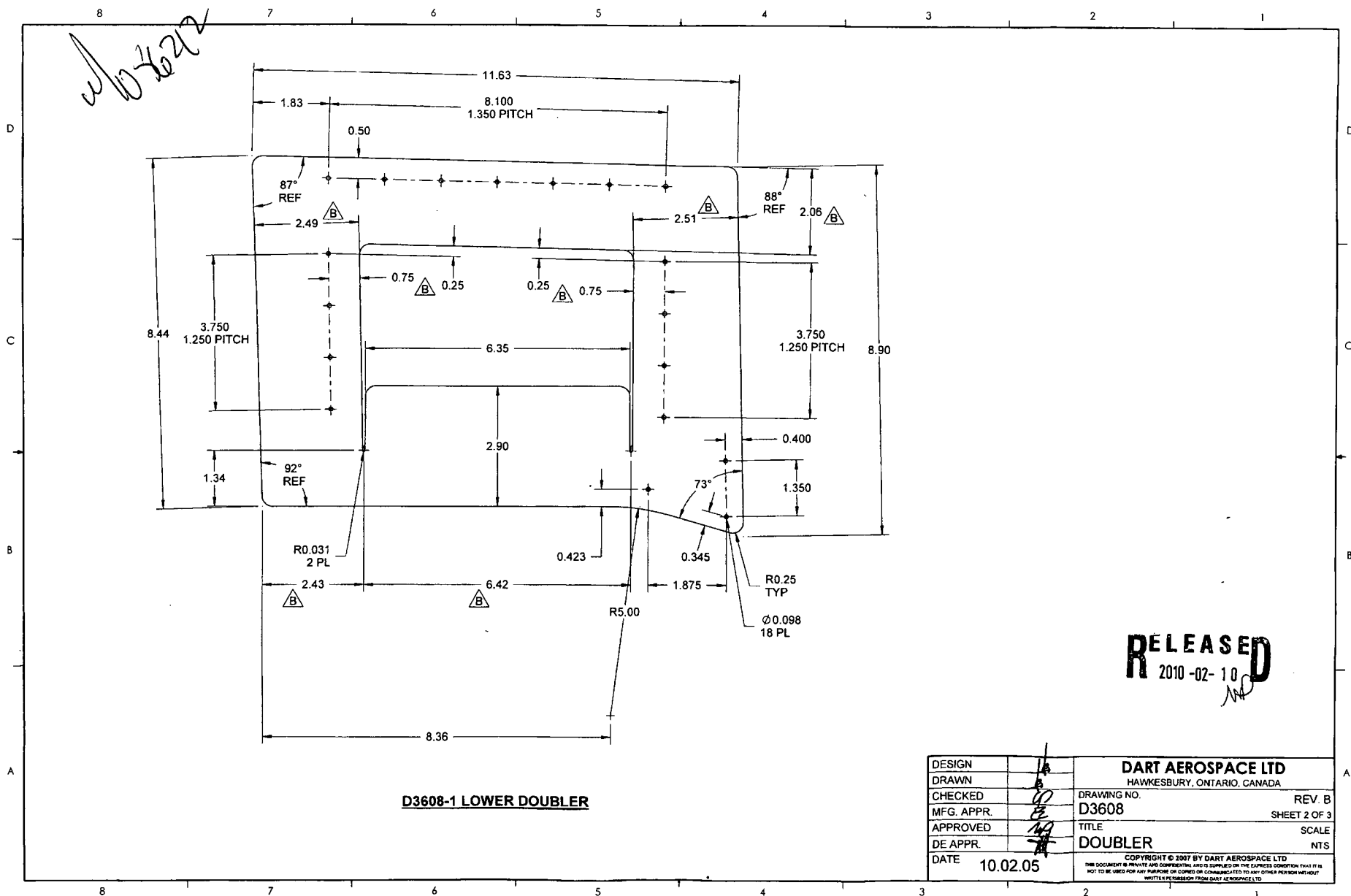
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK
PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3608-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.80 lbs EACH

B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARD; ELIMINATED D3608-1E3-3F; DELETED BENDING DETAILS. REASON: D3608-1/3 NOW SOLD TO CUSTOMERS UNBENT PER PAR#09-097.		MB	10.02.05
A	NEW ISSUE		MB	07.04.11
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE LTD		REV. B	
DRAWN	HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 3	
CHECKED	DRAWING NO. D3608		SCALE NTS	
MFG. APPR.	TITLE DOUBLER		DATE 10.02.05	
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8 7 6 5 4 3 2 1

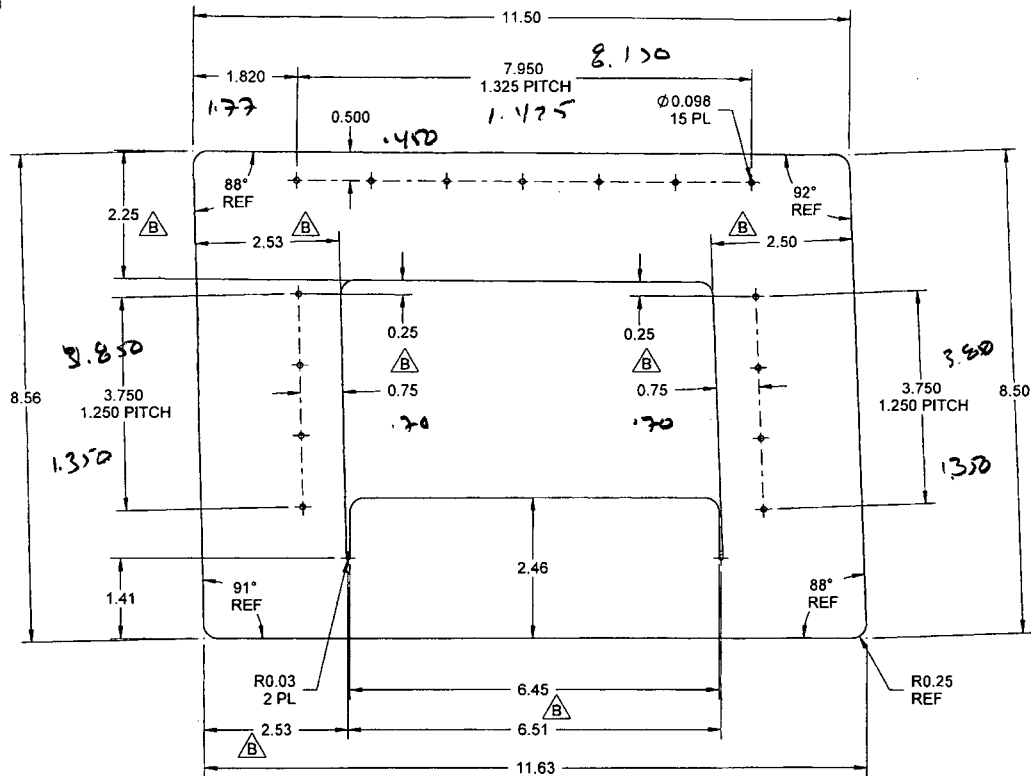
W/O 422



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2010-02-10

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W04672



D3608-3 UPPER DOUBLER

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2010-02-18

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